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**D4776-3**

**Job Sheet 188093**



Part No: D4776-3

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Job Created: 1/3/19

Due Date: 1/4/19

Type: SOLD

Job Qty: 8 ea

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG D4776 REV:E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation     | 8 Ea  | 1/4/19     | 1/4/19   | 0.00      | 0.00    | Start Up Machining-3  |           |          |
| 100   | Bandsaw                | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.14    | Bandsaw1              |           |          |
| 110   | CNC Vertical Machining | 8 pcs | 1/4/19     | 1/4/19   | 0.26      | 6.96    | HAAS1-5               |           |          |
| 120   | QC                     | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.00    | QC2 Machining-3       |           |          |
| 130   | QC                     | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.00    | QC8 Machining-3       |           |          |
| 140   | HandFinish             | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.21    | HandFinish1           |           |          |
| 150   | QC                     | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.00    | QC7-4                 |           |          |
| 160   | Powdercoat             | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.10    | Powdercoat1           |           |          |
| 170   | QC                     | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.00    | QC3                   |           |          |
| 180   | Packaging              | 8 pcs | 1/4/19     | 1/4/19   | 0.00      | 0.00    | Packaging3-2          |           |          |
| 190   | QC21-SA                | 8 Ea  | 1/4/19     | 1/4/19   | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168 DWG REV: \_\_\_\_\_ FOLIO REV: \_\_\_\_\_ 2- deburr and break all sharp edges

1138951 160 - START TIME: 4:30 OVEN TEMPERATURE: 320° FINISH TIME: 5:00

### Job BOM

| Part / Item          | Component Name          | Quantity            | Operation             | Container |
|----------------------|-------------------------|---------------------|-----------------------|-----------|
| M6061T6B2.500X01.500 | 6061-T6 Bar 2.50 X 1.50 | 3.0880 ft (.386 ea) | 90-Start up Operation | 5124463   |

### Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated |
|-----------------------|----------------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6B2.500X01.500 | 3        | 50        | 0         |

**DART**  
AEROSPACE

Container No: S141721



Part: D4776-3

Job No: 188093

Serial No/Batch: S141721

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/03/19

MB

R/U

| Part Specifications |                 |                                |                |          |                  |
|---------------------|-----------------|--------------------------------|----------------|----------|------------------|
| Spec No             | Description     | Target/Tolerance               | Limits         | Type     | Special Comments |
| 1                   | Skidtube Clevis | 4.250Inches ± 0.030            | 4.280<br>4.220 |          |                  |
| 2                   | Skidtube Clevis | 2.250Inches ± 0.030            | 2.280<br>2.220 |          |                  |
| 3                   | Skidtube Clevis | 1.688Inches ± 0.010            | 1.698<br>1.678 |          |                  |
| 4                   | Skidtube Clevis | 0.880Inches ± 0.030            | 0.910<br>0.850 |          |                  |
| 5                   | Skidtube Clevis | 0.510Inches + 0.010<br>- 0.000 | 0.520<br>0.510 |          |                  |
| 6                   | Skidtube Clevis | 1.063Inches ± 0.010            | 1.073<br>1.053 |          |                  |
| 7                   | Skidtube Clevis | 1.380Inches ± 0.030            | 1.410<br>1.350 |          |                  |
| 8                   | Skidtube Clevis | 0.190Inches ± 0.030            | 0.220<br>0.160 |          |                  |
| 9                   | Skidtube Clevis | 1.000Inches ± 0.030            | 1.030<br>0.970 |          |                  |
| 10                  | Skidtube Clevis | 0.484Inches + 0.006<br>- 0.001 | 0.490<br>0.483 | Diameter |                  |
| 11                  | Skidtube Clevis | 0.500Inches ± 0.030            | 0.530<br>0.470 |          |                  |
| 12                  | Skidtube Clevis | 0.550Inches ± 0.030            | 0.580<br>0.520 |          |                  |
| 13                  | Skidtube Clevis | 3.150Inches ± 0.010            | 3.160<br>3.140 |          |                  |
| 14                  | Skidtube Clevis | 1.130Inches ± 0.030            | 1.160<br>1.100 |          |                  |
| 15                  | Skidtube Clevis | 0.688Inches ± 0.010            | 0.698<br>0.678 |          |                  |
| 16                  | Skidtube Clevis | 0.397Inches + 0.006<br>- 0.001 | 0.403<br>0.396 | Diameter |                  |
| 17                  | Skidtube Clevis | 1.813Inches ± 0.010            | 1.823<br>1.803 |          |                  |
| 18                  | Skidtube Clevis | 0.190Inches ± 0.030            | 0.220<br>0.160 | Radius   |                  |
| 19                  | Skidtube Clevis | 0.130Inches ± 0.030            | 0.160<br>0.100 | Radius   |                  |
| 20                  | Skidtube Clevis | 0.440Inches ± 0.030            | 0.470<br>0.410 | Radius   |                  |
| 21                  | Skidtube Clevis | 0.125Inches ± 0.010            | 0.135<br>0.115 |          |                  |
| 22                  | Skidtube Clevis | 0.380Inches ± 0.030            | 0.410<br>0.350 |          |                  |
| 23                  | Skidtube Clevis | 0.750Inches ± 0.030            | 0.780<br>0.720 |          |                  |
| 24                  | Skidtube Clevis | 0.250Inches ± 0.030            | 0.280<br>0.220 | Radius   |                  |

Plex 1/3/19 8:56 AM dart.lacelle.linda